



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2652
Job Sheet 169435



Part No: D2652

Job Qty: 450 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 12/11/17

Job Tracking No:

Due Date: 12/18/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A IPP Rev:B 02.06.13 Now machined in house. NG

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	450 Ea		12/15/17	0.00	0.00	Start Up Machining-1		
100	Hardinge	450 pcs		12/18/17	0.00	16.56	Hardinge		
120	QC	450 pcs		12/18/17	0.00	0.00	QC8		
130	Packaging	450 pcs		12/18/17	0.00	0.00	Packaging3-1		
140	QC21-SA	450 Ea		12/18/17	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO FA252 & DWG D2652

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R0.500	25	14	0	0

5021849

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.600inches ± 0.010	0.610 0.590		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.305inches + 0.000 - 0.002	0.305 0.303		
4	Bushing	0.191inches + 0.005 - 0.001	0.196 0.190		
5	Bushing	0.500inches ± 0.010	0.510 0.490		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.000Degrees ± 0.010	20.010 19.990		
8	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work

Pi

Nc

Date :



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AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Bushing

PART NO: D2652

Revision:
Operation:
Change No:

Start up Operation

Mfg Date: 12/17/17
Job No: 169435

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

Pressure/Forced	☐
Bending	☐
Centre Not Concentric	☐
Cracks	☐
Crimp/Kink/Ripple/Wave	☐
Cuffs	☐
Crushing	☐
Heat Treat	☐
Wave/Twist in Tube	☐
Marks/Chatter	☐

FAULT CATEGORY

Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Contamination	☐	Out of Sequence	☐	Part Moved	☐
Countersink	☐	Off-set	☐	Drawing	☐
Cut Too Short	☐	Mislabeled	☐	Finish	☐
Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :

